



Dart Aerospace Ltd.
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D5336-041
Job Sheet 187737



Part No: D5336-041

Job Qty: 1 ea

Part Name: Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/13/18

Job Tracking No:

Due Date: 12/28/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEETS 1,2,3,7 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM IPP REV:B 17.03.27 AS PER REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/28/18	12/28/18	0.00	0.00	Start Up Large Fab-6		
100	Large Fab	1 pcs	12/28/18	12/28/18	0.00	8.02	Large Fab 1		
110	QC	1 pcs	12/28/18	12/28/18	0.00	0.00	QC9		
120	QC	1 pcs	12/28/18	12/28/18	0.00	0.00	QC5		
130	Powdercoat	1 pcs	12/28/18	12/28/18	0.00	0.11	Powdercoat4		
140	HandFinish	1 pcs	12/28/18	12/28/18	0.00	0.75	HandFinish3		
150	QC	1 pcs	12/28/18	12/28/18	0.00	0.00	QC3		
160	Packaging	1 pcs	12/28/18	12/28/18	0.00	0.00	Packaging3-2		
170	QC21-SA	1 Ea	12/28/18	12/28/18	0.00	0.00	QC21		

Part Op 100 - 1- Assemble ribs , weld as per dwg D5336 using DT10196 2- Weld hinge (3) and Mounting brackets as per dwg Descriptions: D5336 ***inspect before welding mesh*** 3- Cut mesh as per dwg D5334-1 4- Tack weld mesh on basket as per dwg D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

130 - *** Mask holes and sides of hinge prior to powdercoat*** Start Time: 10:00 Oven Temperature: 320°

Finish Time: 10:30 AM 138940

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea) ✓	90-Start up Operation	5 125289
D4016-3	Hinge Half, Lid	3 Ea (3 ea) ✓	90-Start up Operation	5 121277
D5332-041	Rib Assembly	2 Ea (2 ea) ✓	90-Start up Operation	5 127093
D5332-1	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5 127087
D5332-13	Rib	3 Ea (3 ea) ✓	90-Start up Operation	5 1174905
D5332-15	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5 138274
D5332-19	Rib	2 Ea (2 ea) ✓	90-Start up Operation	5 140921
D5335-1	Data Plate	1 Ea (1 ea) ✓	90-Start up Operation	F163096
M304EX0.75-16F	Expanded Metal Flat SS	8.1600 sf (8.16 ea)	90-Start up Operation	5 109214

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	34	0
	D4016-3	3	190	0

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

D5332-041	2	2	0
D5332-1	2	4	0
D5332-13	3	9	0
D5332-15	2	1	0
D5332-19	2	0	0
D5335-1	1	2	0
M304EX0.75-16F	8	1,818	0
Part Specifications			
Specifications could not be found.			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐																	
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)															
Description Work Order Deviation				Disposition																	
				Completed By																	
				Lead hand / Supervisor																	
				QC / QA Coordinator																	
MULT CATEGORY																					
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Date: 01/14/19



Container No: S144443

Part: D5336 - 041

Job No: 187737

Serial No/Batch: S144443

Revision:

Inspector:

Exp Date:

Instructions: Various STC's